

Date: Friday, 2/23/2007 8:33:27 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLEVIS
Job Number : 30911	
Estimate Number : 12498	
P.O. Number : <u>N/A</u>	Part Number : D351613
This Issue : 2/23/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3516 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 29573	Material : <u>N/A</u>
Written By : _____	Due Date : 3/30/2007 Qty: 8 Um: Each
Checked & Approved By : <u>[Signature]</u> 01.02.23	
Comment : Est Rev. New Issue 06-06-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0218 sf(s)/Unit Total : 0.1747 sf(s)

304/316 .125 Sheet 11GA

(M304S11GA)

Batch: m102817

m1 07 03 05

(8)

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

1-Cut as per Dwg D3516

Dwg Rev: B

Prog Rev: B

m1 07 03 05

(8)

2-Deburr if necessary

> m1 07/03/07 x8

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

m1 07 03 05

(8)

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

07/03/06

(8)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

Form as per Dwg D3516

S13 07/03/08 (8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/12

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

Date: Friday, 2/23/2007 8:33:27 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLEVIS

Job Number: 30911

Part Number: D351613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

AA 07/03/09 (8)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5 Co 7/3/9 (5)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(8) 07/03/12

Job Completion



U 07-03-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				

NOTE: Date & initial all entries

DART

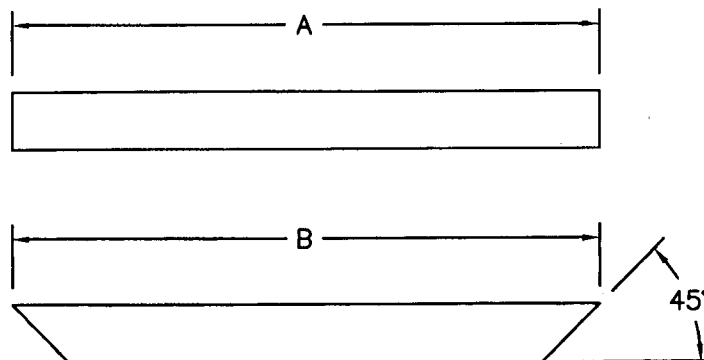
DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>PH</i>	APPROVED <i>PH</i>	DRAWING NO. D3516	REV. B SHEET 1 OF 5
DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE NTS
A	06.06.21	NEW ISSUE	
B	06.07.25	ADD (4) D3516-13, (6) D3516-11 WAS (10), SEE TR-D119-756-1 REV. A	

RELEASED

06.11.28 *PH***PARTS LIST FOR D3516-041 BASKET BASE ASSEMBLY**

PART NO	QUANTITY	LENGTH A	LENGTH B	DESCRIPTION
D3516-1	2	—	102.00	RIB
D3516-3	2	—	25.50	RIB
D3516-5	8	26.75	—	RIB
D3516-7	3	45.50	—	RIB
D3516-9	4	N/A	N/A	RIB
D3516-11	6	N/A	N/A	CLEVIS
D3516-13	4	N/A	N/A	CLEVIS
D2232-3	2	N/A	N/A	HINGE PLATE
D2327-3	2	N/A	N/A	BUSHING
D2581	2	N/A	N/A	MOUNTING BRKT
D3442-1	2	N/A	N/A	SHIM

B {

**NOTES:**

- 1) CUT LENGTH/SHAPE PER DIAGRAM AND PARTS LIST
- 2) FRAME MATERIAL: AISI 304/316 SS, 3/4 X 3/4 X 0.065 WALL SQUARE TUBING (REF. DART SPEC. M304TS0.750W.065)
- 3) MESH MATERIAL: 3/4-16F EXPANDED SS (REF. DART SPEC. M304EX0.75-16F)
- 4) WELD PER DART QSI 004
- 5) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

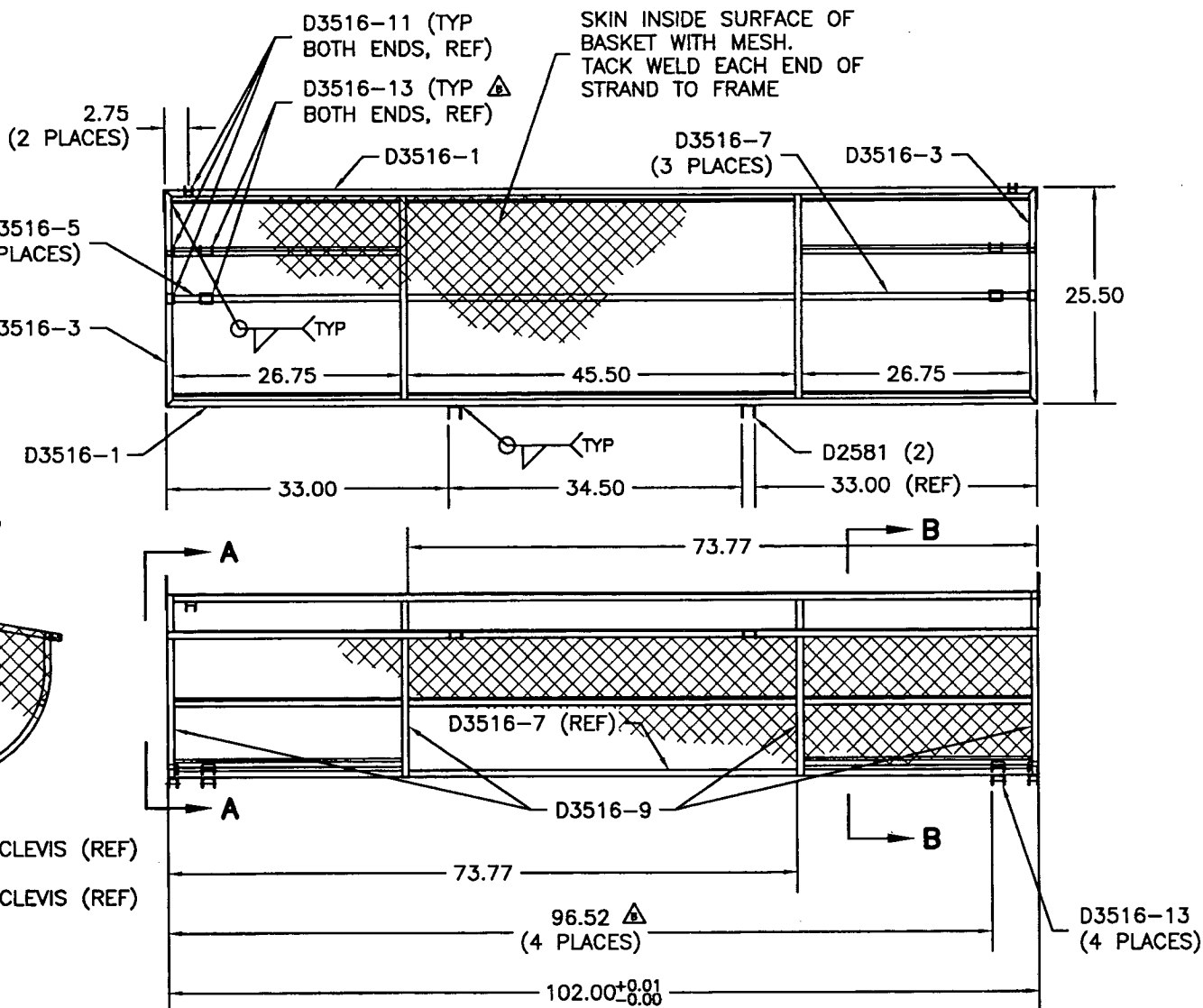
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CHECKED	BY	APPROVED	REV. B
DATE	06.07.25	TITLE	BASKET BASE ASSEMBLY (A119)
		DRAWING NO.	D3516
		SHEET 2 OF 5	SCALE



D3516-041 BASKET BASE ASSEMBLY

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06/11/28

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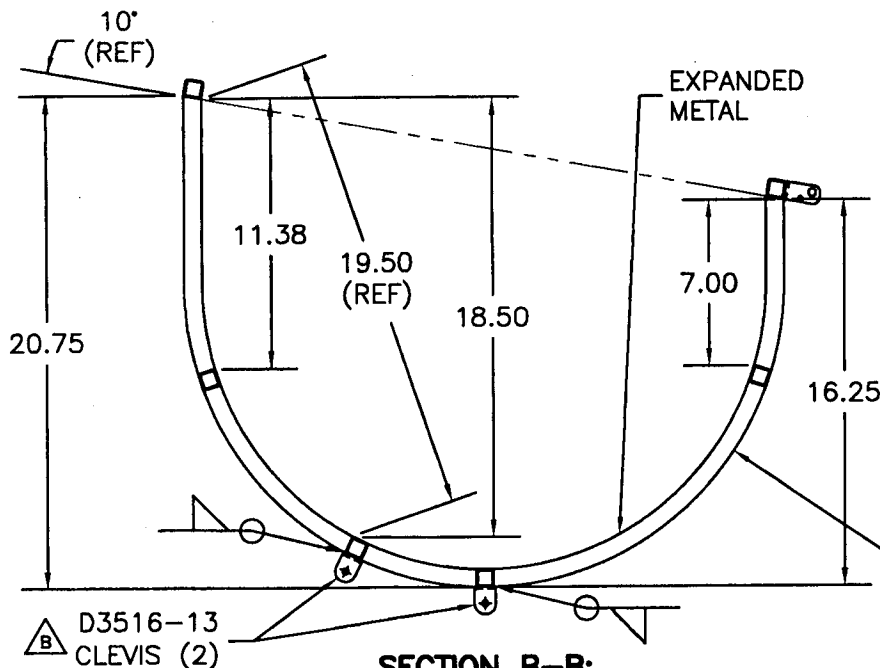
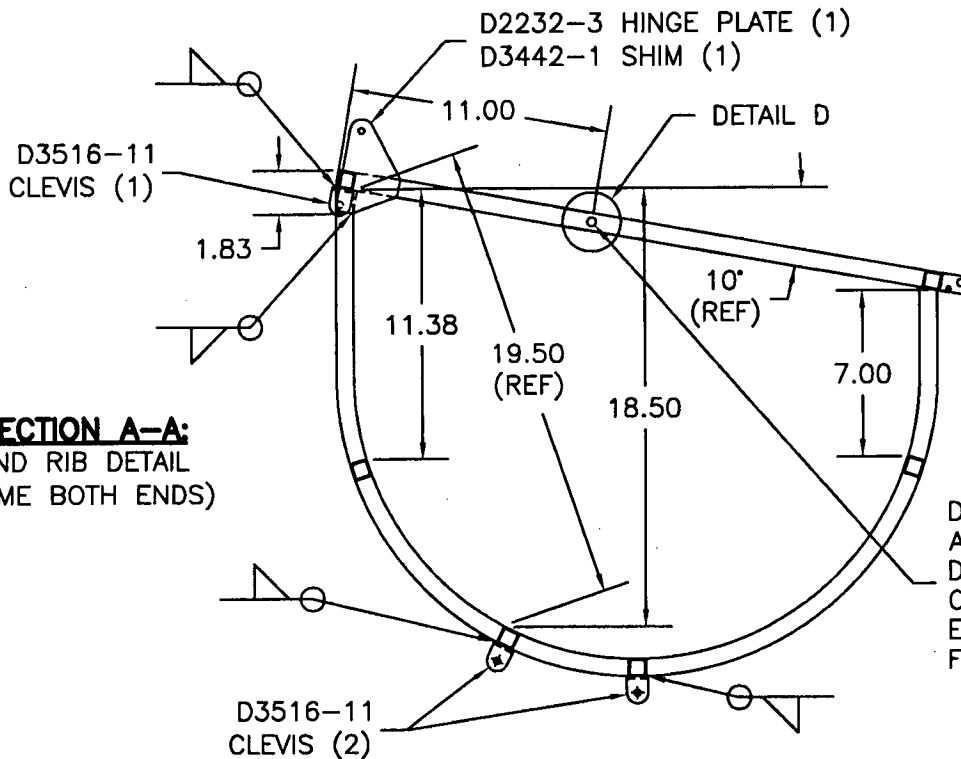
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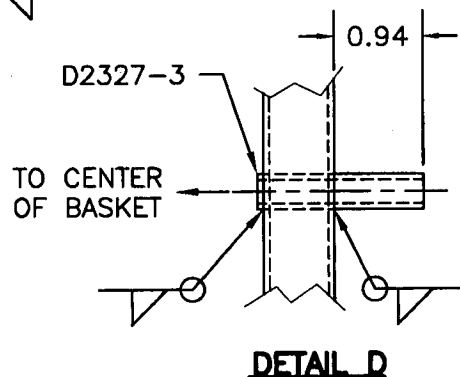
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CHECKED <i>PH</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3516	REV. B SHEET 3 OF 5
DATE 06.07.25	TITLE BASKET BASE ASSEMBLY (A119)		SCALE 1:8

SECTION A-A:
END RIB DETAIL
(SAME BOTH ENDS)



SECTION B-B:
CENTER RIB DETAIL
(2 PLACES)

**RELEASED**06.11.28 *[Signature]*

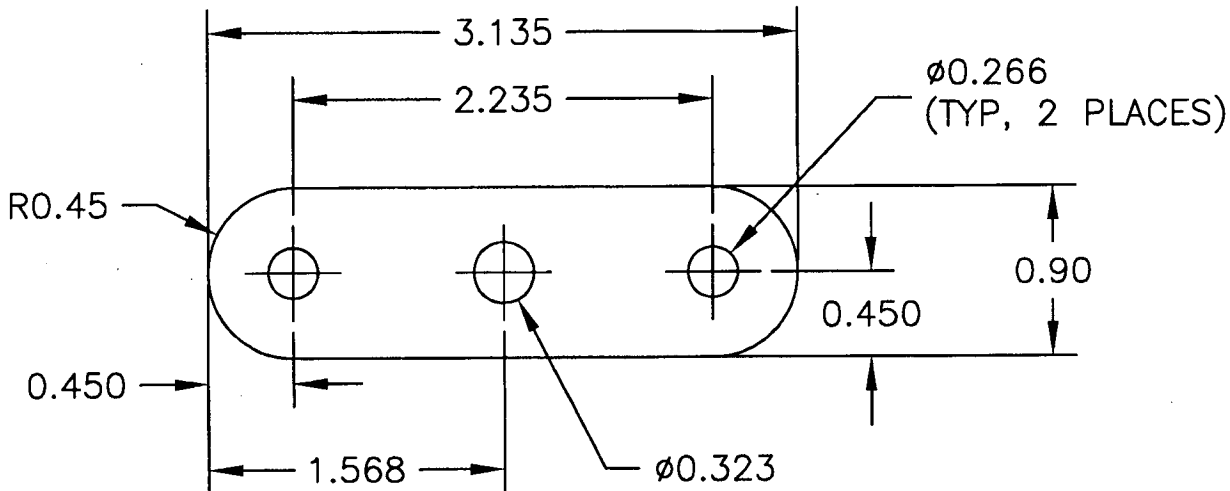
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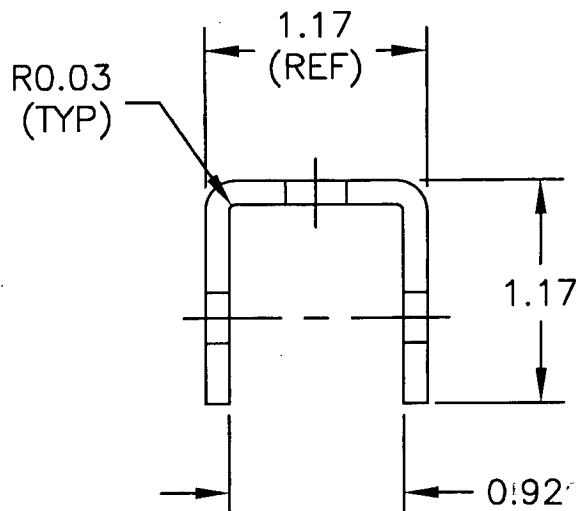
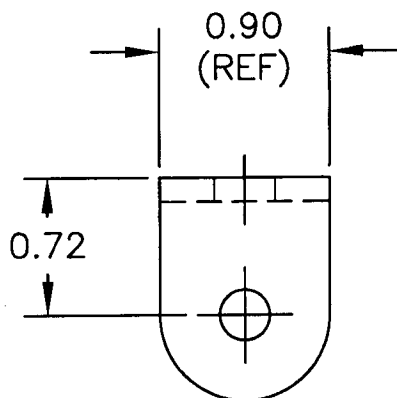
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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1

**D3516-11F CLEVIS FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)

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D3516-11 CLEVIS BENDING DETAIL

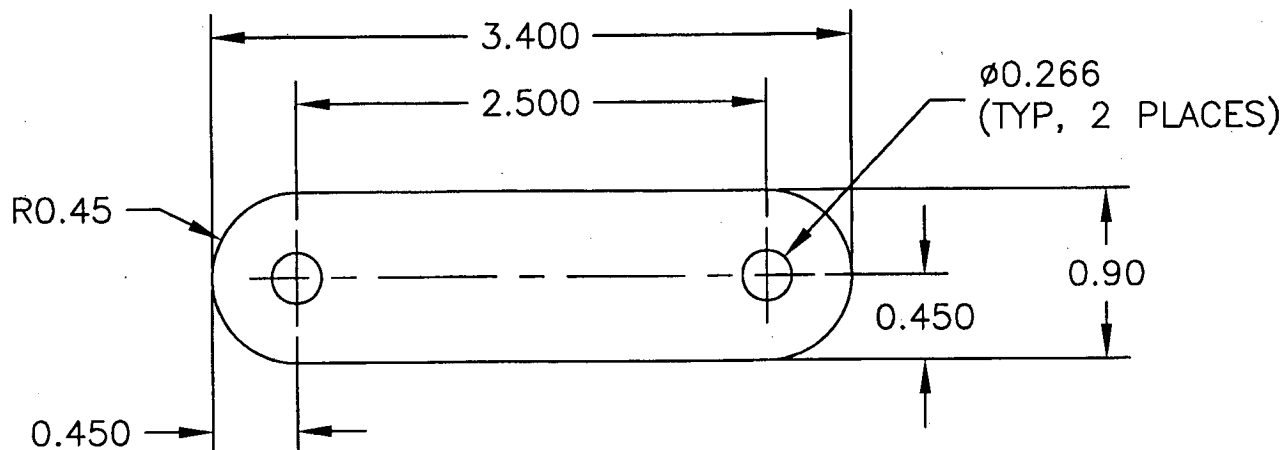
- 1) MATERIAL: MAKE FROM D3516-11F
2) ALL DIMENSIONS ARE IN INCHES
3) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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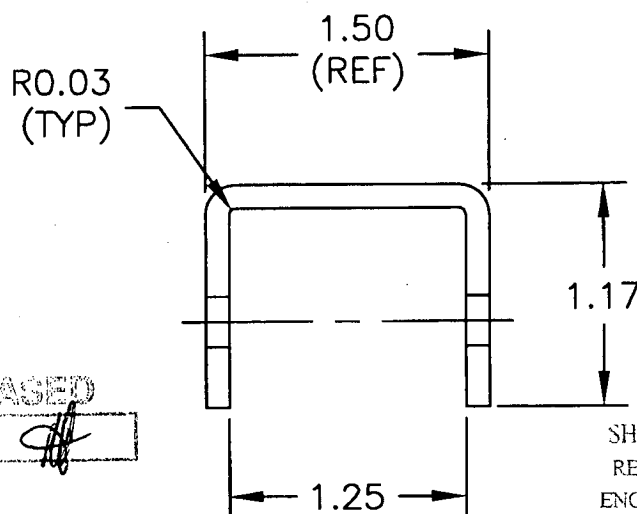
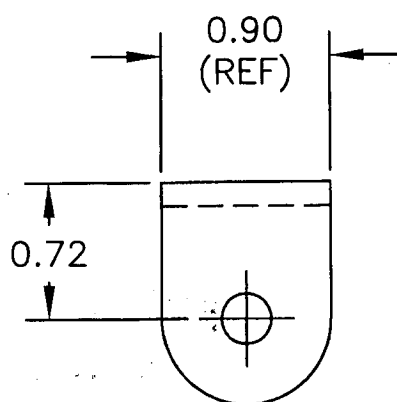


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DATE 06.07.25		TITLE BASKET BASE ASSEMBLY (A119)	SCALE 1:1



D3516-13F CLEVIS FLAT PATTERN

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)



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06/11/28 *CH*

D3516-13 CLEVIS BENDING DETAIL

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